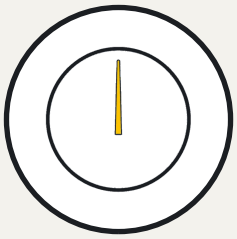
TAKT

The customer's drumbeat.



Take the time you actually have, divide by what the customer actually needs, and you get takt - the pace the floor must hit. Faster is overproduction. Slower is a queue. On the beat is lean.



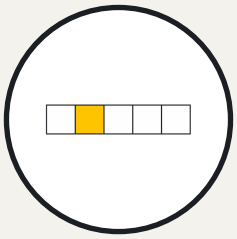
TIME AVAILABLE

The shift, minus the breaks



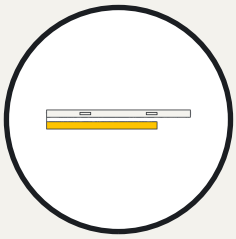
DEMAND

What the customer needs today



DIVIDE

That pace is takt



COMPARE

Every timed job, against the beat

THE ARITHMETIC

480 minutes minus 45 of breaks, over 850 cartons - about thirty seconds a carton.

IT CHANGES

Demand moves, takt moves. Yesterday's pace is not today's.

UNDER IS NOT WINNING

Beating takt all day builds pallets nobody ordered yet.

THE TIMER KNOWS

Every time study compares itself to takt - green under, red over.

Takt is not how fast you can go. It is how fast you must.